

# Work Order ID 62431

September 30, 2010 8:00:06 AM



Page 1

Item ID: D4172-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Z-Shape Section Assembly, RH

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/9/30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	A								

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

ST 10-10-12



110

QC5- Inspect part completeness to step on W/O

0.00



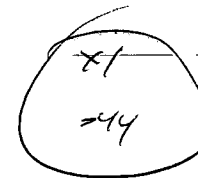
QC

Memo

0.00

Quality Control

8/10/10/13



120

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo



0.00

Packaging

ST 10 10 13



Dart Aerospace Ltd

W/O: 62431		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-12	100	Back of clearance along inside edge of D4172-4 angle (nut plate in the way) install rivet CR3213-4-04 From opposite side 1 location	IT	10-10-12	1	 10.10.12	 10/10/12

Part No: D4172-044 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62431**

September 30, 2010 8:00:06 AM

Page 2

Item ID: D4172-044

Accept

Setup Start

Revision ID:

Stop

Item Name: Z-Shape Section Assembly, RH

Start Date: 9/30/10 Start Qty: 1.00

Required Date: 10/15/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/2010  
MF  
10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

September 30, 2010 8:00:06 AM

**Parent Item:** D4172-044











**Parent Item Name:** Z-Shape Section Assembly, RH

**Start Date:** 9/30/10**Required Date:** 10/15/10

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-1 		Manufactured	No			100	Each	0.0000	1	1			
Supporting Plate						B62425	x1				RT	10-10-07	
D4172-4 		Manufactured	No			100	Each	0.0000	1	1			
Support Angle						B61428	x1				RT	10-10-07	
D4172-5 		Manufactured	No			100	Each	0.0000	1	1			
Support Angle						B62429	x1				RT	10-10-07	
CR3213-4-04 		Purchased	No			100	Each	200.0000	46	46			
Rivet						104	291				RT	10-10-07	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST312				200					
				115742				200					
MS20426AD3-5 		Purchased	No			100	Each	6,356.000	22	22			
RIVET						M4179					RT	10-10-07	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST316				6356					
				104874				2356					
				110398				4000					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

September 30, 2010 8:00:06 AM

Work Order ID: 62431



Parent Item: D4172-044



Parent Item Name: Z-Shape Section Assembly, RH

Start Date: 9/30/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

MS21075L4 N

10.10.07

Purchased

No

100

Each

23.0000

11

11



Nutplate

115837



IT 10-10-07

Location

Loc Qty

Loc Code

ST303

23

115708

23

September 30, 2010 8:00:06 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

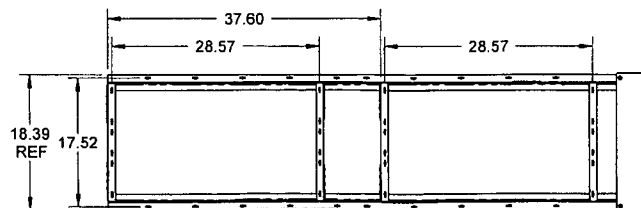
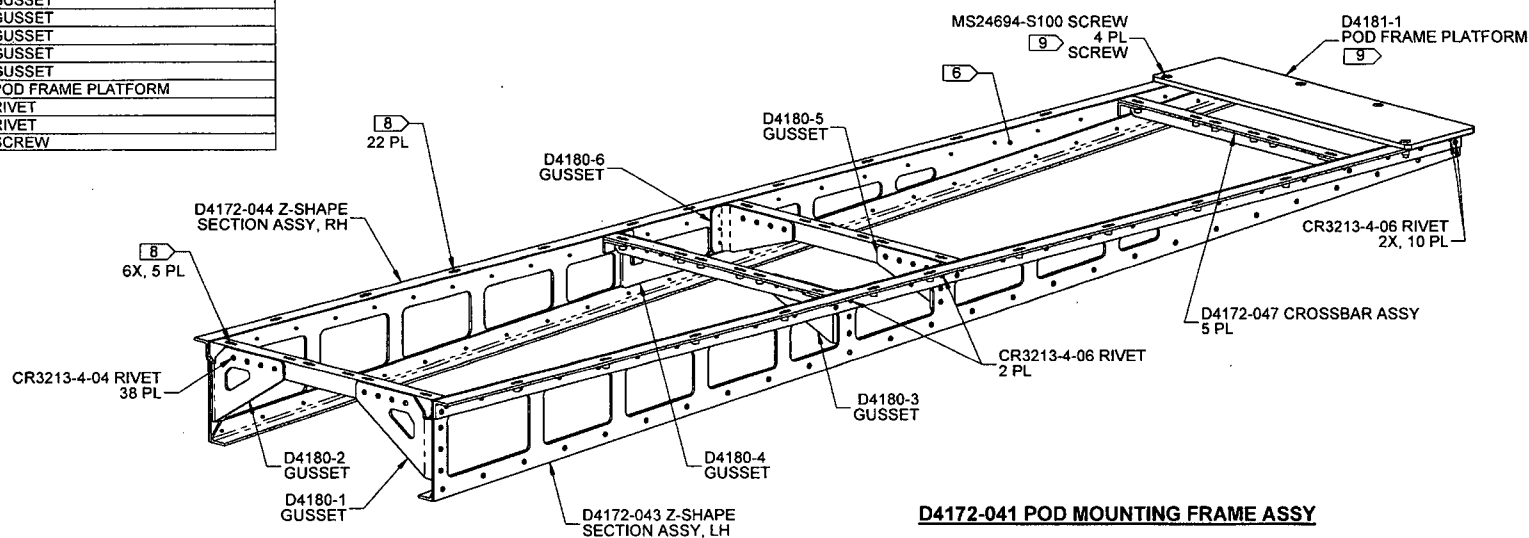
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW

C21019/30  
W10:62431



SUPPLEMENTAL VIEWS

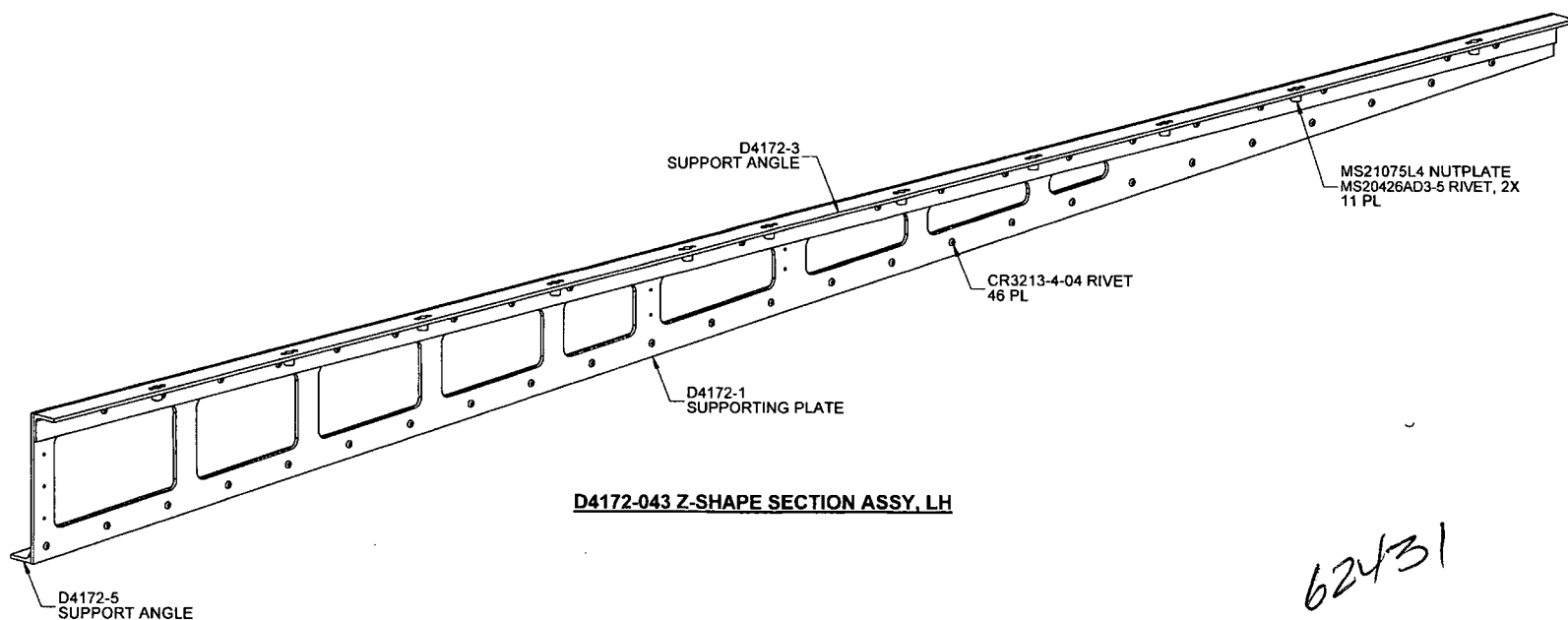
- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1 (PERMANENT INK MARKER)
  - 7) WEIGHT: 15.0 lbs
  - 8) MASK PRIOR TO POWDER COATING
  - 9) INSTALL AFTER POWDER COATING

RELEASED  
2010-09-29

REV.	DESCRIPTION	MB	DATE
A	NEW ISSUE		10.09.15
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.09.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4172	REV. A
TITLE POD MOUNTING FRAME ASSY	SHEET 1 OF 7
SCALE NTS	
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



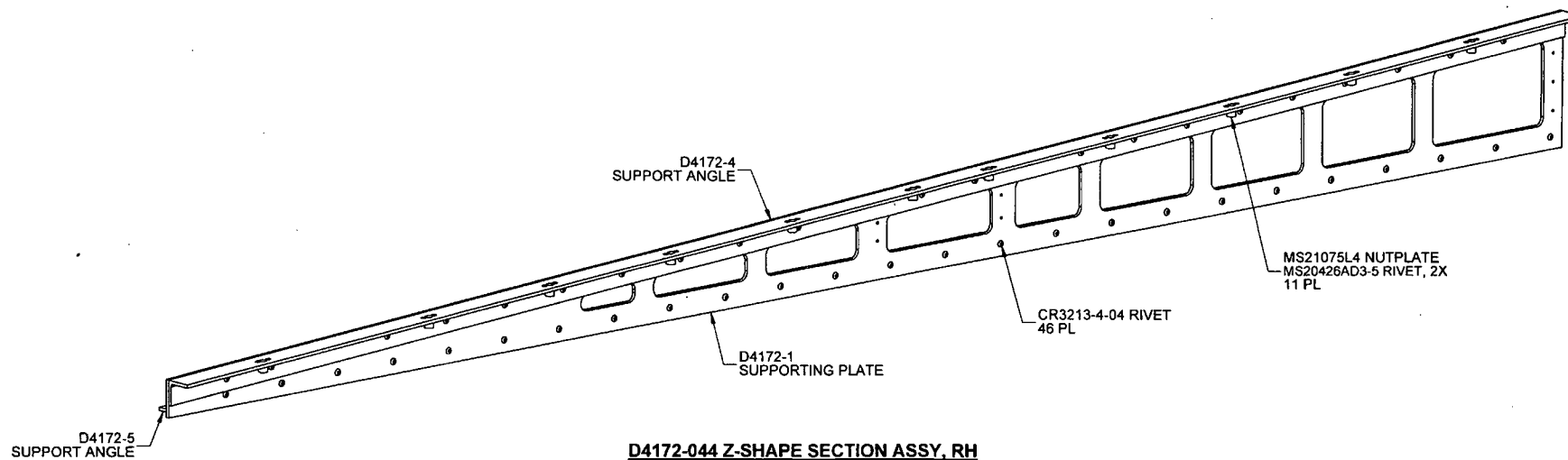
NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 2.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. <b>D4172</b>	REV. A
MFG. APPR.		SHEET 2 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		<b>POD MOUNTING FRAME ASSY</b> NTS	
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 2010-09-29

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ITEM	QTY -044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE

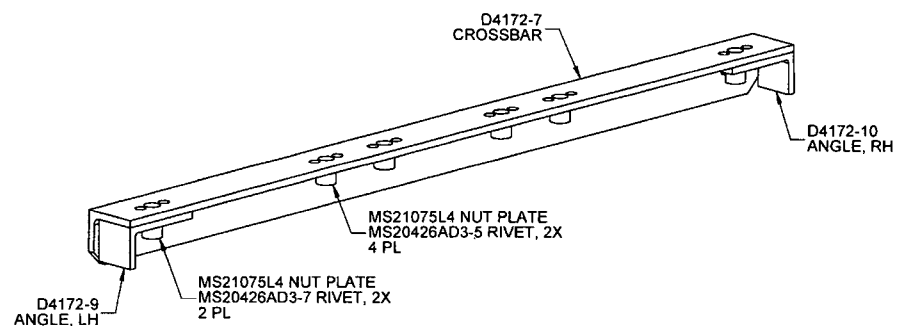


- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.14 lbs

DESIGN	J	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. A
MFG. APPR.	R	D4172	SHEET 3 OF 7
APPROVED	12	TITLE	SCALE
DE APPR.	#	POD MOUNTING FRAME ASSY NTS	
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2010-09-29  
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ITEM	QTY -047	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET



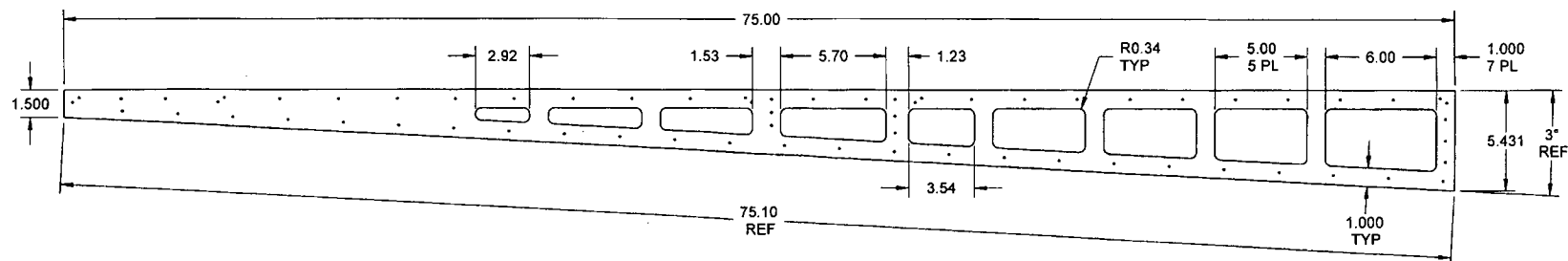
**D4172-047 CROSSBAR ASSY**

- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.18 lbs

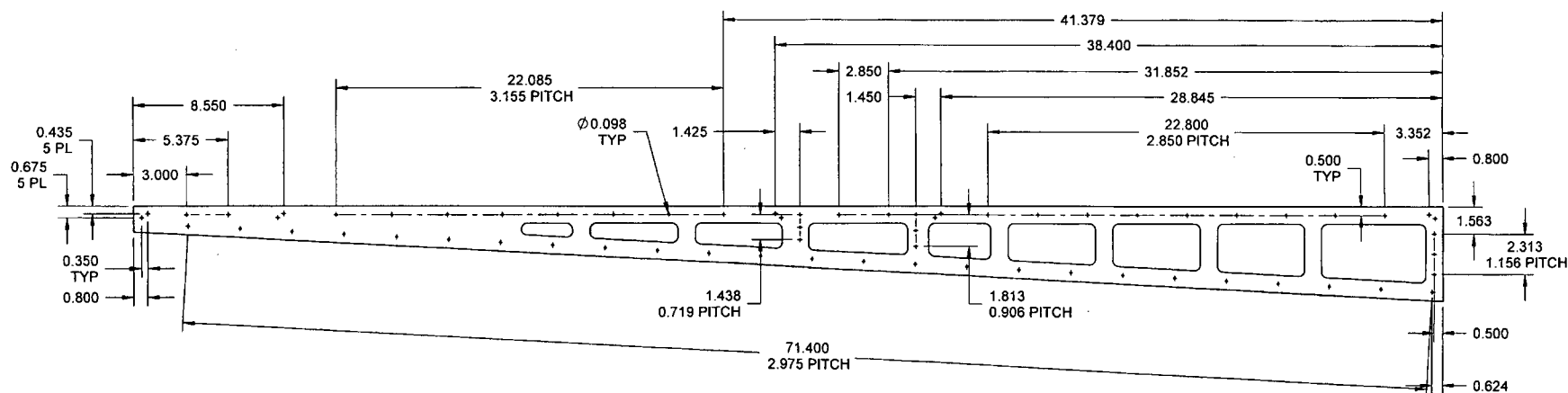
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4172</b>	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>POD MOUNTING FRAME ASSY NTS</b>	
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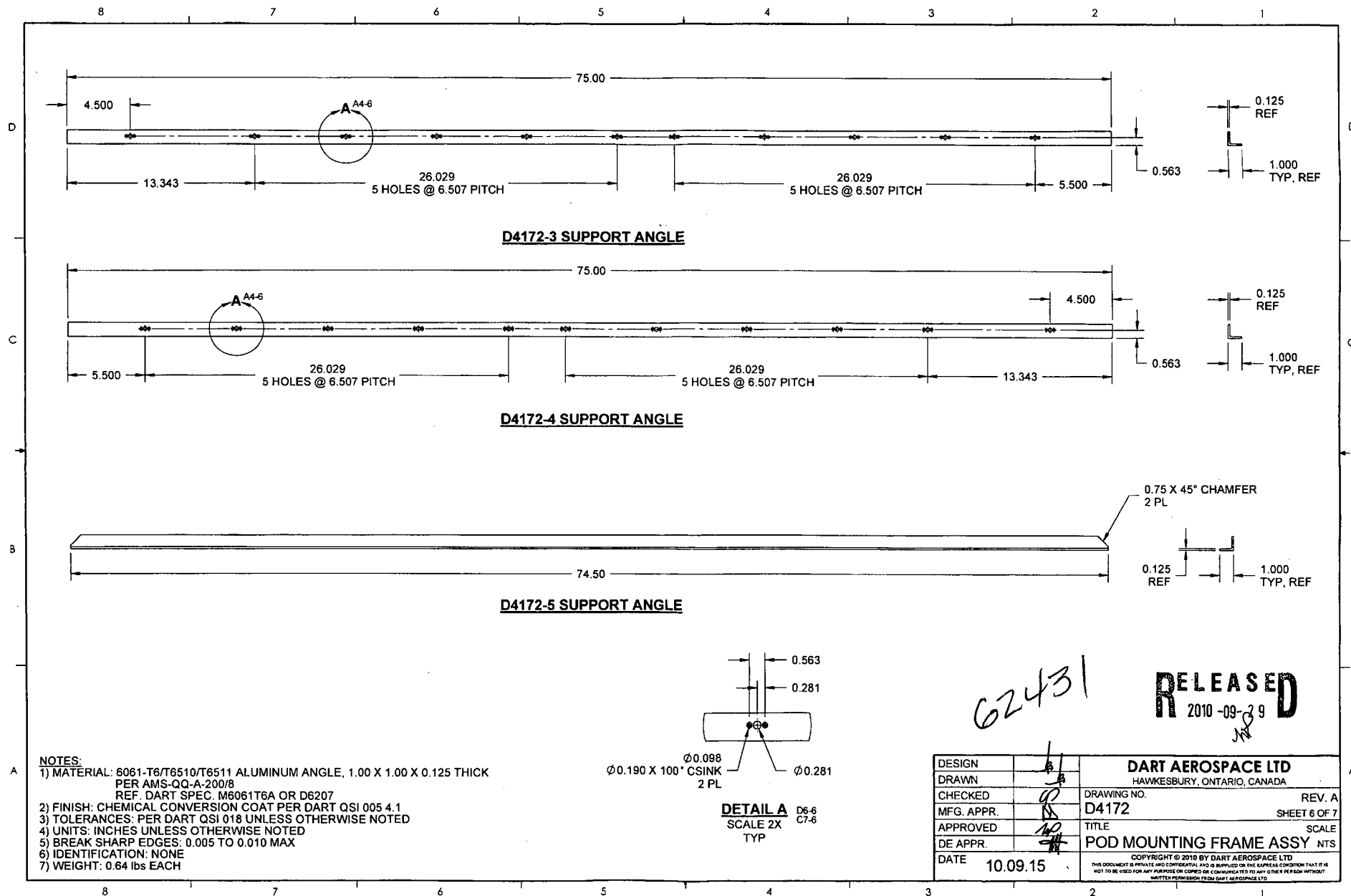
62431  
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2010-09-29  
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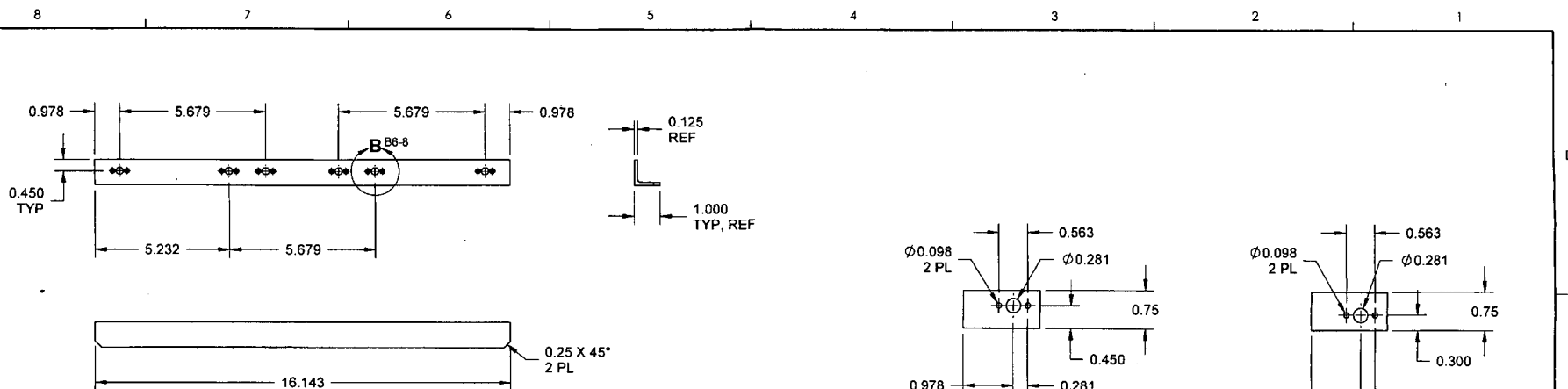
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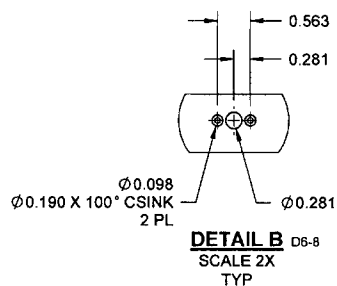
**D4172-1 SUPPORTING PLATE**



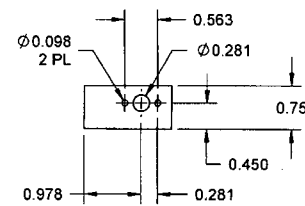




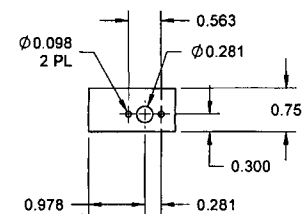
**D4172-7 CROSSBAR**



**DETAIL B** D6-8  
SCALE 2X  
TYP



**D4172-9 ANGLE**



**D4172-10 ANGLE**

**NOTES:**

- 1) MATERIAL  
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK  
PER AMS-QQ-A-200/8  
REF. DART SPEC. M6061T6A OR D6207  
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK  
PER AMS-QQ-A-200/8  
REF. DART SPEC. M6061T6A OR D6207
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

DESIGN	1	<b>DART AEROSPACE LTD</b>	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D4172	SHEET 7 OF 7
APPROVED	1	TITLE	SCALE
DE APPR.	1	POD MOUNTING FRAME ASSY	NTS
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2010-09-29

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